

Date: Wednesday, 06/09/2006 11:05:20 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GPS BOTTOM MOUNTING	
Job Number	: 28423		Part Number	: D35303	
Estimate Number	: 12521		Drawing Number	: UNDER REVIEW <i>E 06-09-06</i>	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 06/09/2006	S.O. No. : N/A	Drawing Revision	: N/A	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 13/09/2006 Qty: 2 Um: Each	
Previous Run	: N/A		Type	: SMALL /MED FAB	
Written By	: <i>E</i>		Comment	: Est Rev:A New Issue 06-09.06 EC	
Checked & Approved By			Additional Product		

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet
		Comment: Qty.: 0.4865 sf(s)/Unit Total : 0.9729 sf(s) 6061-T6 .040 Sheet (M6061T6S040) Batch: <i>M19380</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3530 Dwg Rev: <i>pre</i> Prog Rev: <i>pre</i>
	2-Deburr if necessary	<i>M 06 09 06</i> (2)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06 09 06</i> (2)
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>E 06.09.06</i>
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Bend as per Dwg D3530 <i>E 06/09/06</i> (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/08/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/07	5	I piece was scrap when bending R 90.0.	<u>Initial</u> <u>06/09/07</u>	Scrap + destroy review bend. R 90.0	<u>SB</u> <u>06/09/07</u>	<u>J</u> <u>06/09/07</u>	<u>J</u> <u>06/09/07</u>	<u>J</u> <u>06/09/07</u>

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-09-08

(1)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-09-14

(1)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06-09-14

(1)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST447

LB 06/09/14

(1)

(1)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

LS 06/09/14

U 06-09-14

Job Completion



ENG APPROVAL

PART INSPECTED AFTER INSTALLATION

PART OK FOR TESTING ONLY

CB 07-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

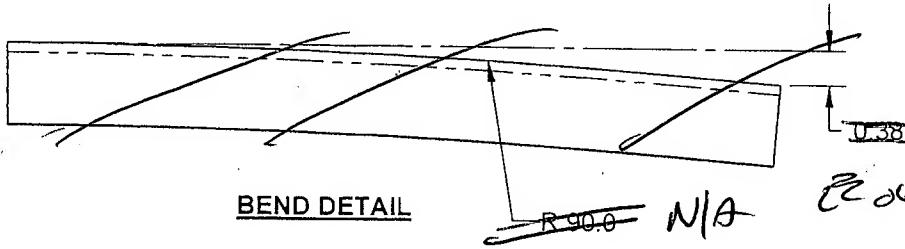
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

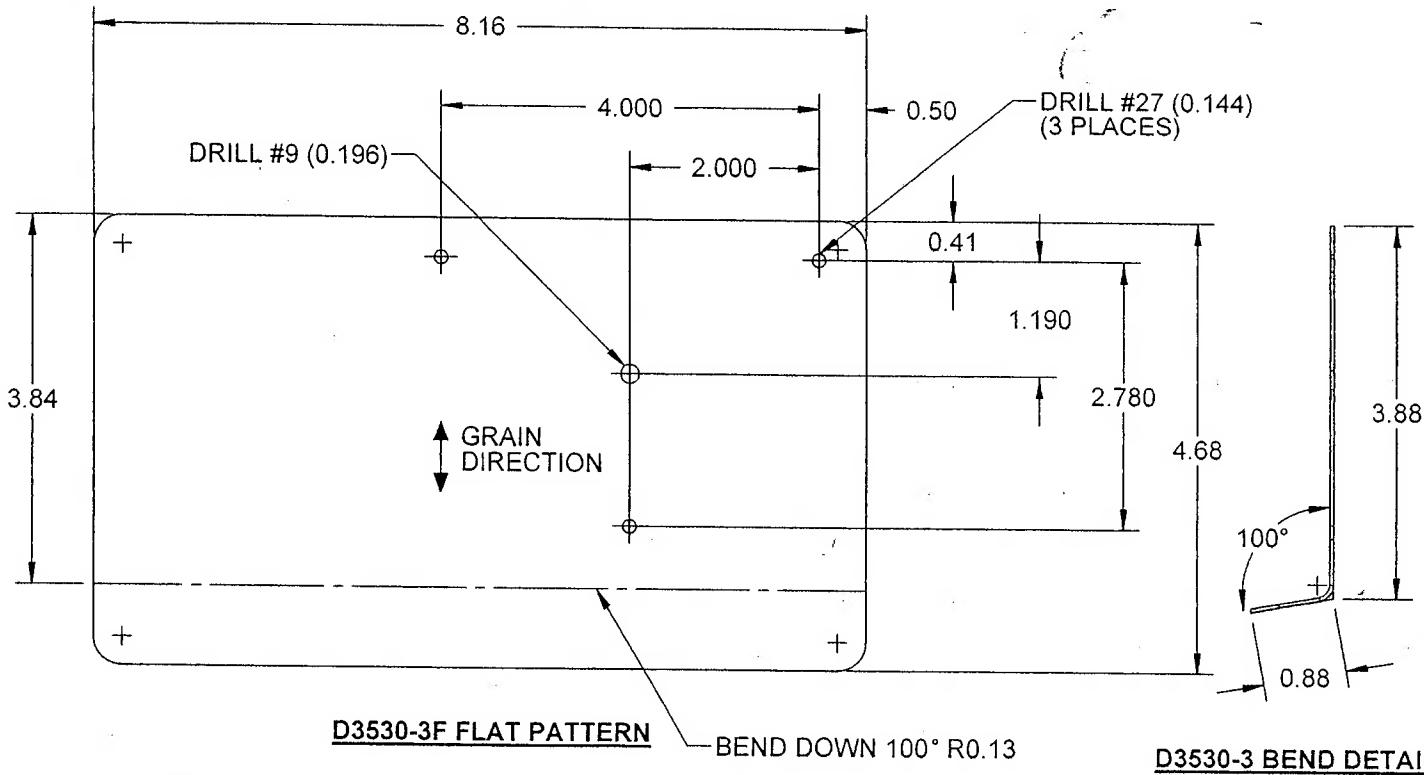
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. D3530		
DATE 06.06.21	TITLE GPS BOTTOM MOUNTING	REV. A SHEET 2 OF 2	SCALE 1:2	



UNDER REVIEW

06.08.22 CB

26.09.08 prototype



D3530-3 MOUNTING PLATE

*EST Due
Prog*

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	28423
Description:	Part Number:	3530-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	<i>M. KUMAR</i>	Audited by:		Prototype Approval:	<i>C.B</i>
Date:	<i>08.05.06</i>	Date:		Date:	<i>07.07.20</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PART INSPECTED AFTER
INSTALLATION. FLAT
PATTERN NOT INSPECTED.
PART OK FOR TESTING
ONLY CB 07-07-20